

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010744**Date Inspected:** 11-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (5AW)

This QA inspector observed a skin flatness survey at the 5AW segment. The surface flatness survey was taken on the exterior side of the side panel on the cross beam side. The out of flatness measurement across the side panel in the transverse direction, between the longitudinal weld joining side panel to side panel of 5AW is 9mm in 630mm (Close to Segment 5AW to 5BW transverse splice). This exceeds the maximum 5mm out of flatness requirement per the approved State letter.

-The weld is identified as: SEG021A-010

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)**FCAW Process:**

Welding of weld joint -005 located on PCMK OBW6, Edge panel crossbeam side. Welder is identified as 220063. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

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OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

FCAW Process:

Welding of weld joint –001 located on PCMK OBW6, Edge panel counterweight side. Welder is identified as 220067. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

OBG # TRIAL ASSEMBLY YARD (6AW-6BW)

SAW Process:

Welding of weld joint –003 located on PCMK OBW6, Deck panel. Welder is identified as 046830. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-2.

SAW Process:

Welding of weld joint –003 located on PCMK OBW6, Deck panel. Welder is identified as 049804. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in 5AW. And prior to issue it was informed to ZPMC QC and ABF QA.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
